

Work Order ID 79090

\*79090\*

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January-19-12 2:54:01 PM

Item ID: D4519-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Relay Bracket

Start Date: 1/19/12 Start Qty: 20.00 \*20\*

Cust Item ID:

Required Date: 1/23/12 Req'd Qty: 20.00 \*20\*

Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4519	A								

100 0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

1312-1-19

6061 .063

Dwg Rev: A

(34)

Prog Rev: A

2-Deburr as required

110 0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1312-1-19

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Item ID: D4519-1 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Relay Bracket  
 Start Date: 1/19/12 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 1/23/12 Req'd Qty: 20.00 \*20\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		SB 12/6/12		count (+24)			
140 *140* Brake NC Brake NC	Bend as per dwg NC BRAKE  Memo	0.00 0.00		SB 12/10/12		(24)			
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		SB 12/11/12		count (+24)			

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Item ID: D4519-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Relay Bracket  
 Start Date: 1/19/12 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 1/23/12 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*160*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>B9E</u>	0.00							
<b>*180*</b>									
Packaging	Memo	0.00							
Packaging									

24 BL 12-1-24

24 X 4 M-L 12/01/24

blib4 P

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Item ID: D4519-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Relay Bracket  
Start Date: 1/19/12      Start Qty: 20.00      **\*20\***      Cust Item ID:  
Required Date: 1/23/12      Req'd Qty: 20.00      **\*20\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

12/1/25

12-01-25

(24)

# Picklist Print

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Work Order ID: 79090

Parent Item: D4519-1

Parent Item Name: Relay Bracket

Start Date: 1/19/12

Required Date: 1/23/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.01.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	353.5696	0.0378	0.7957895		12-1-19	

Location

Loc Qty

Loc Code

MAT021

353.5695684

113608

0

116308

11.4555684

117285

75.414

119331

49.2

119802

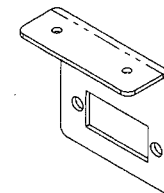
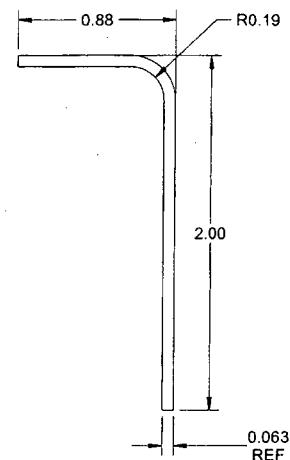
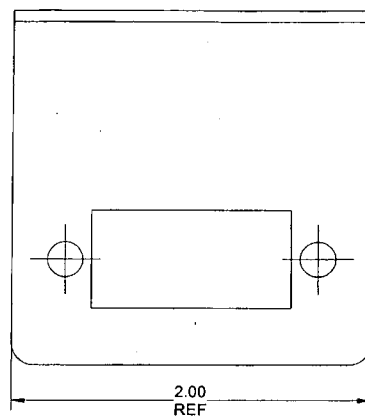
25.5

120218

192

120218

74



# **D4519-1 RELAY BRACKET**

RELEASED  
2012-01-17  
WD

## **NOTES:**

- 1) MATERIAL: MAKE FROM D4519-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

A		NEW ISSUE		RF	11.11.14
REV.	DESCRIPTION			BY	DATE
DESIGN		RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		RF			
CHECKED				DRAWING NO.	REV.
MFG. APPR.				D4519	SHEET 1 OF
APPROVED				TITLE	SCALE
DE APPR.			RELAY BRACKET	NT	
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**D4519**  
 SHEET 1 OF 2  
 TITLE SCALE  
**RELAY BRACKET** NTS

